

Work Order ID 133791

Wednesday, June 17, 2015 2:53:19 PM

133791

Page 2

Item ID: D3407-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Stem
Start Date: 6/17/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/17/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA002</u>	0.00							
130						<u>10</u>		<u>MAL</u>	<u>15-07-14</u>
Packaging	Memo	0.02							
Packaging	LOCATION: WA001								
140	QC21- Final Inspection - Work Order Release	0.00							
140						<u>MCS</u>		<u>JUL 14 2015</u>	
QC	Memo	0.00							
Quality Control									

MCS JUL 14 2015

Picklist Print

Wednesday, June 17, 2015 2:53:22 PM

Page 1

Work Order ID: 133791

133791

Parent Item: D3407-1

D3407-1

Parent Item Name: Stem

Start Date: 6/17/2015

Required Date: 6/17/2015

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A05.10.18New issueKJ/EC

IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M174R0.750

Purchased

No

100

f

13.1200

0.459

5

M174R0 750

SL 15-6-22

17-4 round bar .750

Location

Loc Qty

Loc Code

MAT030

13.12

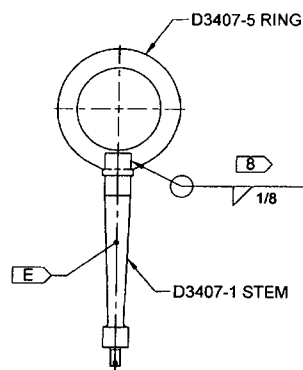
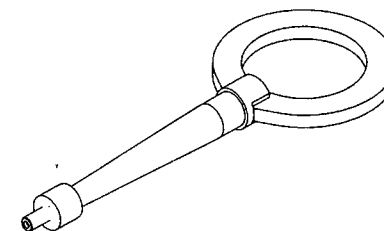
m132320

13.12

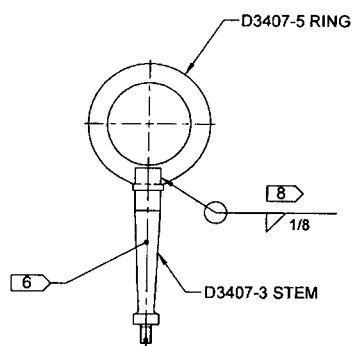
5.8

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

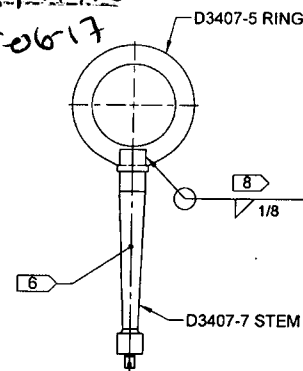
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
NO AMENDMENT
WITHOUT NOTICE
WORK ORDER
133791 MLC
150617



D3407-041 TOW RING



D3407-043 TOW RING



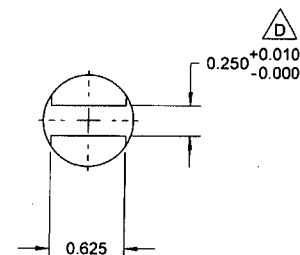
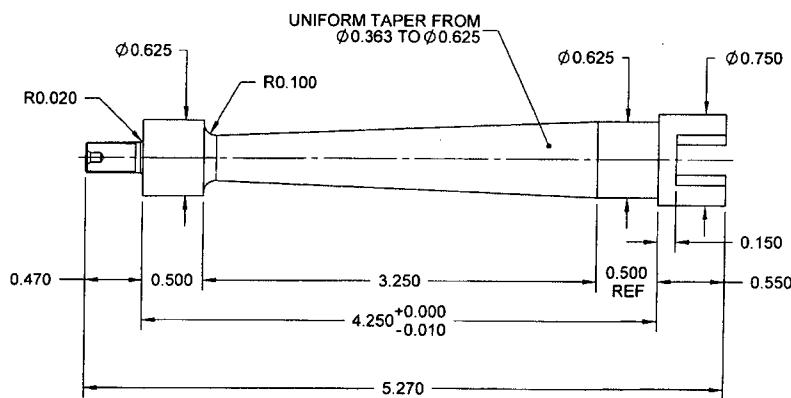
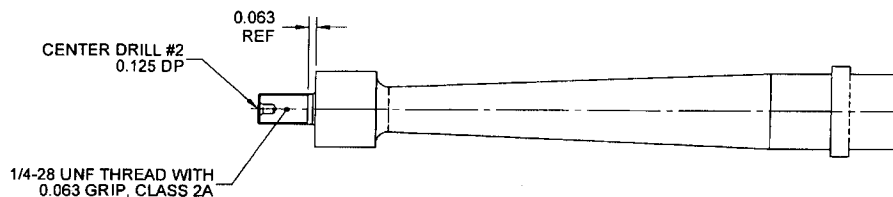
D3407-045 TOW RING

RELEASED

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 5 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3407 TITLE TOW RING SCALE NTS DATE 08.07.23	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. E	SHEET 1 OF 5
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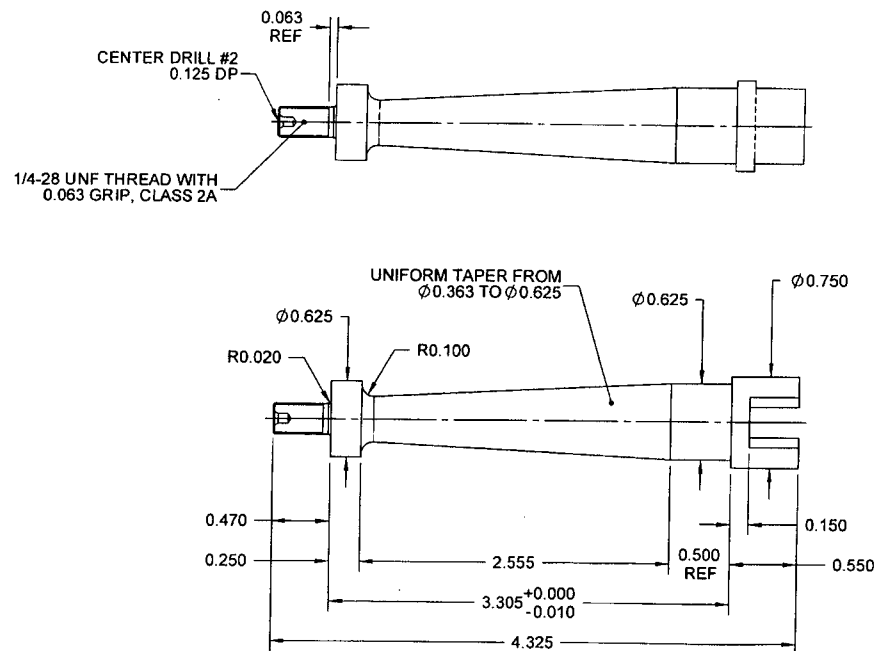


D3407-1 STEM

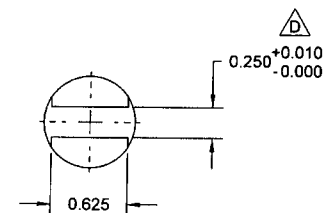
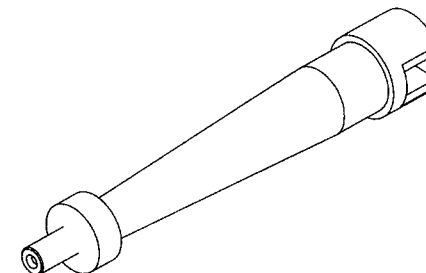
RELEASED
08-05-23

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

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MFG. APPR.		D3407	SHEET 2 OF 5
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DE APPR.		TOW RING	NTS
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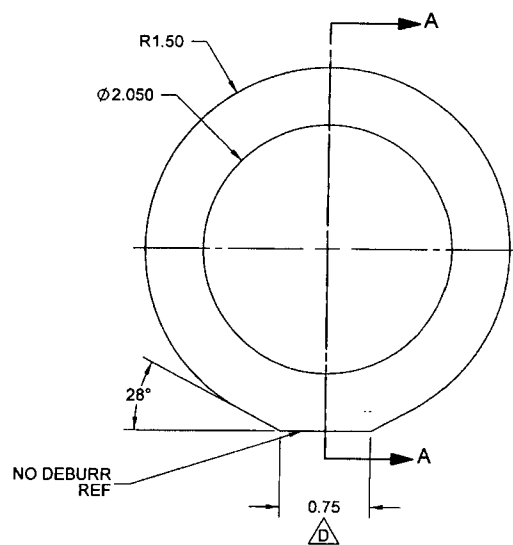
D3407-3 STEM



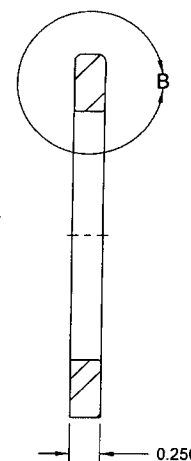
RELEASED

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

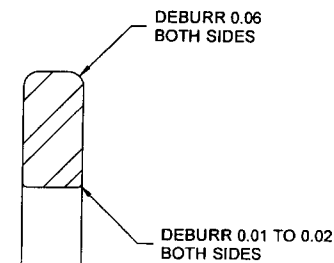
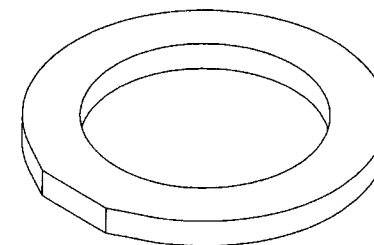
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MFG. APPR.		D3407	SHEET 3 OF 5
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D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

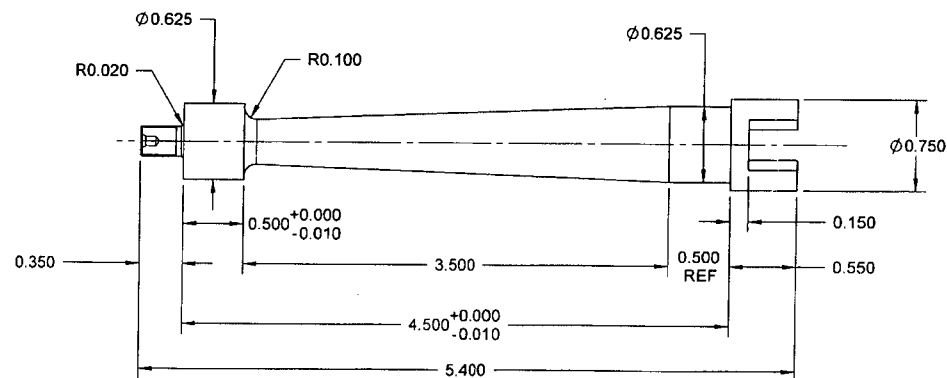
RELEASED
08-07-23

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

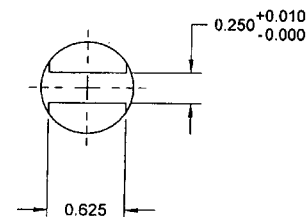
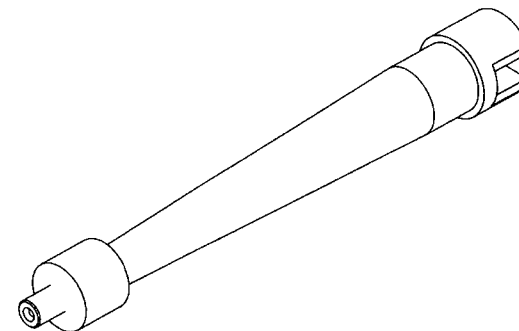
DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	1/21	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
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0.063
REF
CENTER DRILL #2
0.125 DP

1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



E D3407-7 STEM



RELEASED

NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
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MFG. APPR.		D3407	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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DART AEROSPACE LTD		Work Order:	133791
Description: Tow Ring		Part Number:	D3407-1
Inspection Dwg: D3407 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	0.063	/		vern	SL-10
1/4-28 UNF	Max: 0.2668 Min: 0.2635	0.265	/		mic	SL-4
Major Ø	Max: 0.249 Min: 0.2425	0.246	/		mic	SL-4
Ø0.625	+/-0.010	0.629	/		vern	
Ø0.363	+/-0.010	0.365	/		-	
Ø0.750	+/-0.010	0.751	/		-	
R0.100	+/-0.010	0.100	/		-	
0.470	+/-0.010	0.470	/		-	
0.500	+/-0.010	0.500	/		-	
3.250	+/-0.010	3.250	/		-	
4.250	+0.000/-0.010	4.247	/		HGs	3/006
5.270	+/-0.010	5.269	/		vern	
0.150	+/-0.010	0.151	/		}	
0.550	+/-0.010	0.552	/			
0.625	+/-0.010	0.623	/			
0.250	+0.010/-0.000	0.260	/			

Measured by:	<i>SL</i>	Audited by:	<i>mf</i>	Prototype Approval:	N/A
Date:	15-6-21	Date:	15/06/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	
B	07.07.18	Tolerances for diameters updated per Machinists	KJ/JLM	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	<i>DD</i>